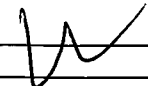


S14

Dart Aerospace Ltd.

Date: Wednesday, 24/09/2008 1:55:51 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOAT SKID LH
Job Number :	42276		
Estimate Number :	12550		
P.O. Number :		Part Number :	D206642514
This Issue :	24/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	24/09/2008	Project Number :	N/A
Previous Run :	28891	Drawing Revision :	L
	Type :	Material :	
	SKIDTUBES	Due Date :	06/10/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :			
Comment :	Est Rev:A New Issue 06-10-06 JLM Est Rev:C 07-02-23 As per IIN D206-642 Rev K JLM est rev D 07.06.06 added K642-514 EC Est Rev:E 07-12-05 ECN 1080p Rev:L DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



JUD 08.10.08



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-514 CHG002

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	42276A	FLOAT SKIDTUBE ASSEMBLY
-----	--------	-------------------------



Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY

1 x D206-642-545 Batch

42276A

SS 08/10/08 (X)

4.0	D206648013	GHW Modification
-----	------------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GHW Kit

Batch:

42315

SS 08/10/08 (X)

5.0	D29322	Saddle RH Out, 206
-----	--------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

206 Saddle Right side

batch:

40280

SS 08/10/08 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 24/09/2008 1:55:51 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH

Job Number: 42276

Part Number: D206642514

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D29332

Saddle RH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

206 Saddle Right

batch:

40280 41129

7.0

D29382

Saddle RH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

206 Saddle Right side

batch:

41131

8.0

D29392

Saddle RH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

206 Saddle Right Side

batch:

39914

9.0

AN3C41A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch:

M108084

10.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

batch:

41549

11.0

MS210433

Nut



Comment: Qty.: 49.0000 Each(s)/Unit Total : 49.0000 Each(s)

Nut

batch:

M109147

12.0

D36725

Phenolic Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

PHENOLIC WASHER

batch:

35521

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 24/09/2008 1:55:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH

Job Number: 42276

Part Number: D206642514

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Nut

batch

M109148

SS 08/10/08 (XU)

20.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Ring

batch

B42211

SS 08/10/08 (XU)

21.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

washer

batch

4 0285

SS 08/10/08 (XU)

22.0

D34571

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch

41016

SS 08/10/08 (XU)

23.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Set Screw

batch

37705

want take Batch.

SS 08/10/08 (XU)

24.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Saddle Spacer

batch

41130

SS 08/10/08 (XU)

25.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Saddle Spacer

batch

42262

SS 08/10/08 (XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 24/09/2008 1:55:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH

Job Number: 42276

Part Number: D206642514

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN3C36A

BOLT



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

BOLT

batch

M109233

AS 08/10/08 (X)

27.0

AN3C35A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

BOLT

batch

M109323

AS 08/10/08 (X)

28.0

AN960C10L

washer



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

washer

batch

M109282

AS 08/10/08 (X)

29.0

D36721

Phenolic Washer



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

PHENOLIC WASHER

batch

42329

AS 08/10/08 (X)

30.0

D33963

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

-Inventory Spacer

batch

30336

AS 08/10/08 (X)

31.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

bolt

batch

M107551

AS 08/10/08 (X)

32.0

AN5C15A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

batch

M105125

AS 08/10/08 (X)

Date: Wednesday, 24/09/2008 1:55:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH

Job Number: 42276

Part Number: D206642514

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0 AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

bolt

batch

M10703

SS 08/10/08 (X)

34.0 AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

bolt

batch

M107289

SS 08/10/08 (X)

35.0 MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch

M108583 x3 M109535 x1

SS 08/10/08 (X)

36.0 D34521

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

28950

SS 08/10/08 (X)

37.0 D34523

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

28951

SS 08/10/08 (X)

38.0 MS21919WDG28

CLAMP



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

CLAMP

18847

SS 08/10/08 (X)

39.0 AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

M105906

SS 08/10/08 (X)

Date: Wednesday, 24/09/2008 1:55:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID LH

Job Number: 42276

Part Number: D206642514

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



08-10-16 (circled)

Comment: INSPECT 100% KITS FOR COMPLETENESS

41.0

PACKAGING 1

PACKAGING RESOURCE #1



(circled)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-514

Location:

73

Rev C

8/10/16

SD

42.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/17 (signature)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-16

B42276A

Date: Wednesday, 24/09/2008 1:56:26 PM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOAT SKIDTUBE ASSEMBLY
Job Number :	42276A		
Estimate Number :	12548		
P.O. Number :		Part Number :	D206642545
This Issue :	24/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3274 REV D
First Issue :	/ /	Project Number :	N/A
Previous Run :	28891A	Drawing Revision :	D
	Type :	Material :	
	SKIDTUBES	Due Date :	06/10/2008
Written By :		Qty:	1
Checked & Approved By :		Um:	Each
Comment :	Est Rev:A New Issue 06-10-06 JLM Est Rev:B Added SS Wearplates & Gaskets 07-02-23 JLM Est Rev:C ECN 1080p 07-12-06 DD verified by: Est Rev:D as per PAR 08-015 08-04-17 DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-545 CHG002

NA

2.0	D26001190	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2600-1-190	3" OD Tube	<u>31032</u>
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RT 08-09-25

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274

RT 08-09-25

2- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

3-Drill #40 Aft cap pilot hole using DT8025

4-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

5-Remove inner indexing ridge on fwd and aft end of skidtube as per Dwg D3274

6-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

SL8-9-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 24/09/2008 1:56:26 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 42276A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

3L 8-9-26

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

① 8-9-26

6.0

D3282041

Float Web (206L/407)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

B 39770

①

M 8-9-30

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

M 09338

Sikaflex expire date:

8-11-1

Start: 8-9-30

Time: 1:25

Finish: 8/10/01

Time: 8:00 AM

(Adhere for 12 hours)

M 8-9-30

RT 08-09-30

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-10-01 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 24/09/2008 1:56:26 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 42276A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. RT 08-10-01

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297"

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

M
8-10-10

10.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3285-1

Fwd Cap

33902 BE 08/09/25

11.0

D2649

Cross Bolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

12 D2649

Crossbolt spacer

341594 (12) M 8-10-10

12.0

D32751

Crossbolt Spacer



Comment: Qty.: 37.0000 Each(s)/Unit Total : 37.0000 Each(s)

Pick:

Qty Part Number

Description Batch

37 D3275-1

Crossbolt spacer

33520 (37) M 8-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 24/09/2008 1:56:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 42276A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod

m/08708 / m-107877 BE 08/09/25

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod

m107877 BE 08/10/02

3-Grind welds flush to Fwd cap on top surface only.

4-Grind cross bolt welds flush as per Dwg D3274.

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

7-10-23

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/06 (X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/06 (X)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Pressure wash m/ 08/10/06

M1109152

m- 08/10/07

(11)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-07 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 24/08/2010 6:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 42276A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3415-041 Nut Plate B 33842

96

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 CCR264SS3-3 Rivet M 101938 *

96

20.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 CR3212-4-03 Rivet M 15918

96

21.0

ALS71032130

Insert



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Insert

Batch: M 105819

96

96

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

ARN/ALPS-3 M 107912

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R Sikaflex-291 M 109338

Sikaflex expire date: 08/11

96 08-10-07 (4)

Date: Wednesday, 24/09/2008 1:56:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 42276A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inspect Nut Plate & Inserts

809/10/07 (X)

24.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total: 80.0000 Each(s)
BOLT
Batch: M109061

yl

25.0

D353515

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B337810

yl

26.0

D353523

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B339134

yl

27.0

D353535

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B338760

yl

28.0

D353539

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B337277

yl

29.0

D353615

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET
Batch: B33964

yl

08-10-07

(X)

Date: Wednesday, 24/09/2008 1:56:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 42276A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D353623

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B33965

HL

31.0

D353635

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B38905

HL

32.0

D353639

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B33966

HL

33.0

D35371

Wearpad



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

WEARPAD

Batch: B41082

HL

34.0

D35373

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: B35697

HL

35.0

AN960C10L

washer



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

80 AN960C10L

Washer M109431

HL

36.0

D36721

Phenolic Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch B39275

HL

08.10.07

(XV)

Date: Wednesday, 24/09/2008 1:56:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 42276A

Part Number: D206642545

Job Number:



Seq. #: Machine Or Operation: Description :

37.0 D34131 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring B33949 JH

38.0 AN4C5A BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt M104936 JH

39.0 AN960C416 ~~Washer~~ *2 attached* WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960C416 Washer M100993 JH

40.0 D2646 Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap 41435 JH

41.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274

A/R Sikaflex-291 M109338

✓ Sikaflex expire date: 08/11

C 4-Inspect for foreign objects as per QSI 024

✓ 5-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: M10912

JH 08-10-07 (21)

Date: Wednesday, 24/09/2008 1:56:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 42276A

Part Number: D206642545

Jgb Number:



Seq. #:

Machine Or Operation:

Description :

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 M10933 B

Sikaflex expire date: 08/11

res 08-10-09 (X)

42.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/07 (X)

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PPD 42276 8/10/16 (A) SP

44.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/17 *JA*

Job Completion



MF 08-10-16

DART

DESIGN	CP	DRAWN BY	PH	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
				D3274	SHEET 1 OF 4
DATE	06.12.19			TITLE	SCALE
				SKIDTUBE ASSEMBLY	NTS
A	04.03.15	NEW ISSUE			
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76			
C	05.03.16	ADD -043; NEW INSERTS			
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET			

RELEASED

07.02.12 *[Signature]*

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

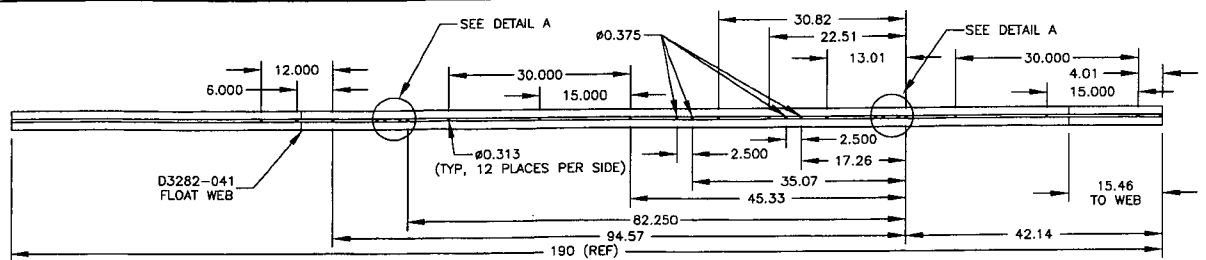
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

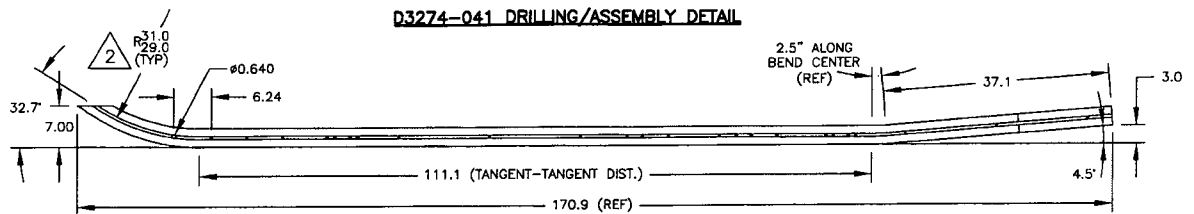
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

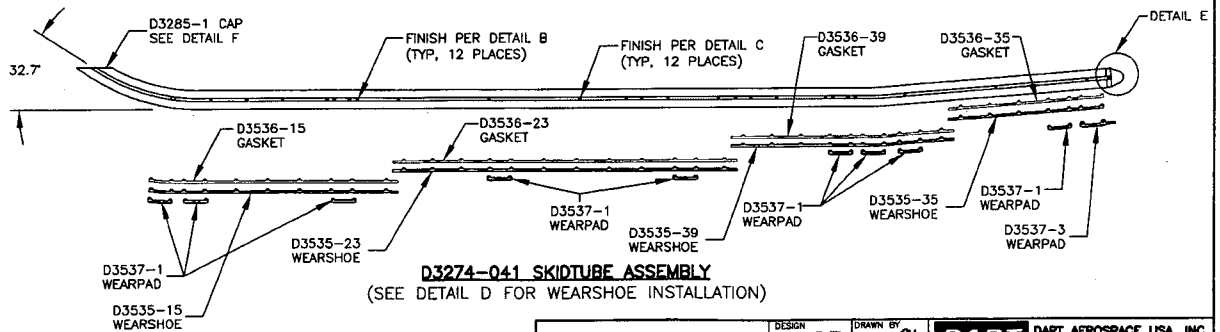
nb 42276A



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.01.12

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		DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

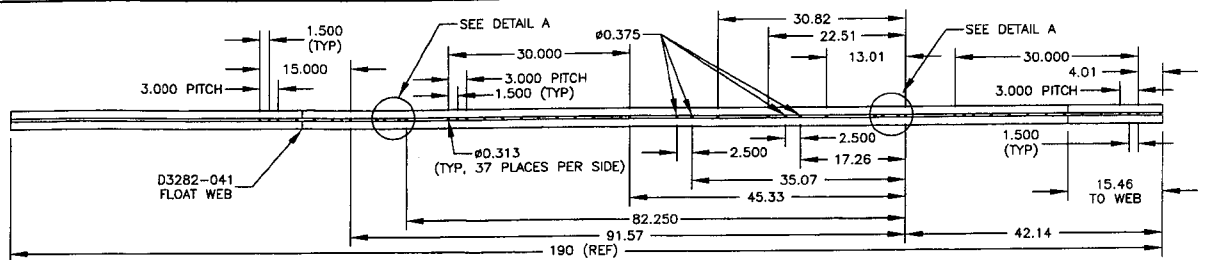
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

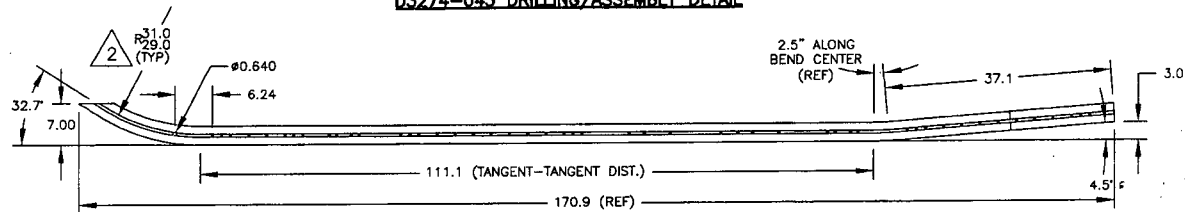
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

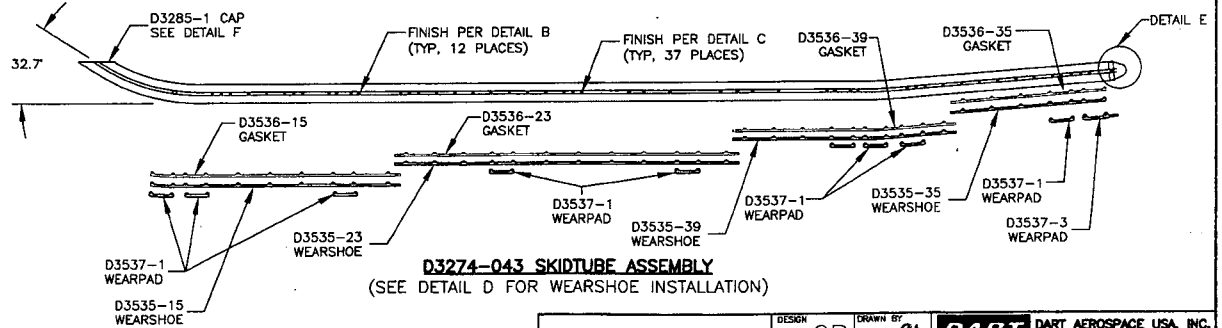
Wb 42276A



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DATE		06.12.19		DRAWING NO.		D3274
TITLE		SKIDTUBE ASSEMBLY		SHEET 3 OF 4		SCALE
						1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

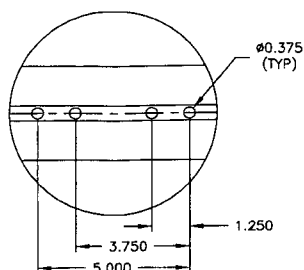
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

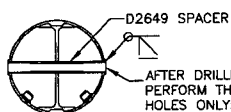
NOTE: Date & initial all entries

NO 42276A

DETAIL A: DRILL DETAIL

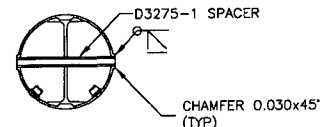


DETAIL B FOR 0.375 HOLES ONLY

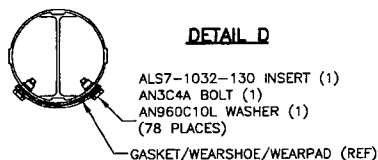


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

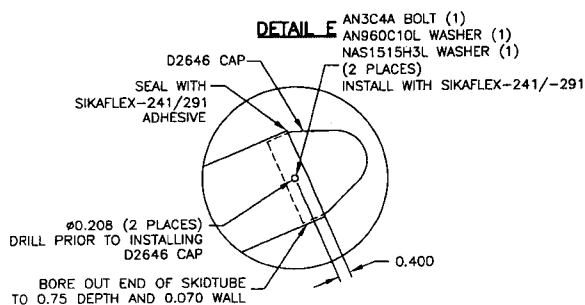
DETAIL C FOR 0.313 HOLES ONLY



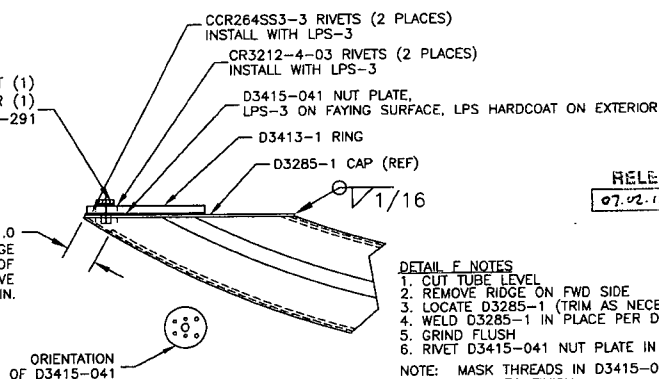
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



- DETAIL F NOTES
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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07.02.12

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		DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 176

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 41952A
Part number: D206 642241
Description: 206 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Pet. Duval Date of Test Coupon 08-09-26
Welder Barclay Elliott Date of Test Coupon 08-09-26

The above named individual is qualified in accordance with AWS D17.1.2001 to weld